Quality Control

Memo

August-23-12 1:05:14 PM Item ID: D350-561-045 Accept *N900040100* Setup Start * **Revision ID:** Item Name: Dual Mirror Accessory Installation, 6 inch Round **Start Date:** 23/08/2012 Start Qty: 2.00 **Cust Item ID: Required Date:** 06/09/2012 Req'd Qty: 2.00 **Customer:** Reference: Run Process Plan: MCJ Date: 12/08/23 Tooling: Approvals: Date: SPC (Y/N): Date: Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D350-561 Rev D 100 0.00 DOCUMENT CONTROL *100* MCJ 17/08/ 0.00 Memo Document Control Photocopy bluefile and create labels per PPP D350-561-045 CHG003 105 Pick Kit 0.00 Packaging 0.00 Memo Packaging QC4-100% Inspect kits for completeness 110 *110* QC 0.00

													DQA:	Date	≥: _	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFOR	MANCE / UP	DATE					•
													QA Closed:	Date	e:_	· · · · · · · · · · · · · · · · · · ·
Work Ord	er:						DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS		
	Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR I	NCR No.						Work Order Update			Large Fab	Composite	_		Supplier		
Root					Desc	ript	ion of work order update	i	nitial	Ac	tion		Sign &		\Box	
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
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	L	Cracks				_	Broken/Damaged		1	on Incomplete			Part Incorre	}-		Weld .
•	L	Crushed/0	Crimped.		L		Burrs		ı	ions Incomplete/	'Unclear	_	Part Lost/Mi	issing		Wrong Stock Pulled.
		Cuffs					Contamination		Mainte				Part Moved			
	<u> </u>	Heat Trea				_	Countersink		Mislabe				Positioned V			
	Inspection Strip in Tube					—1	Cut Too Short		Misread	i			Power Loss/Surge			Other
		Ripples in	Bend			[[Orill Holes		Offset							
	L	Torque W	aves in E	xtrusio	n [[[Drawing		Out of (Calibration						
		Turning So	equence		Γ	F	inish	L	Out of Sequence							

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Item ID: Revision ID:	D350-561-04	45		Accept	*N900	040	100)*	Setup	Start	*N:	S1*
Item Name:	Dual Mirror A	accessory Installation, 6	inch Round							Stop	*N:	S2*
Start Date: Required Date Reference:	23/08/2012 :: 06/09/2012	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	ate:			Run	Start Stop	1/	R1*
	QC:		_ Date:	_ SPC (Y/N):	Da	ate:				эшр	*N	R2*
Sequence ID/ Work Center I	I D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-	Reject Number	Insp. Stamp
120		Packaging						2x	_			<i>C</i> ²
Packaging		Memo		0.00								OF
Packaging		Identify and	pack for shipping as per	PPP D350-561-045	LY B.							19-5.
130		QC21- Final Inspection	- Work Order Release	0.00							1	
130										12	191	11 9
QC		Memo		0.00						1-0	1-1	()
Quality Control											MK	
											_	0-01

										DQA:	Date:	
NCR:	res / No)			WORK ORDER NON-	CO	NFORM	MANCE / UPDATE		•		
										QA Closed:	Date:	
Maril Ord					DISPOSITION		!	AGAINS	T DE	PARTMENT/	PROCESS	
Work Orde	er:				Rework	٦		Skid-tube Crosstub]	Water Jet	Engineering
Part N	No.				Scrap	1	L	Machining Small Fa	-	Pro	d. Eng. Coor.	Quality
raici	•••-				Use-as-is	1	1	noforming Finishin	-		e/Packaging	Other
NCR I	No.				Work Order Update	1	1	Large Fab Composit	~	1	Supplier	
									<u> </u>			
Root				Descri	iption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Cł	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	Ш											
Operator	Ш											
Material												
Setup												
Other												
Process	Ш											
Supplier	<u></u>	-										
Training				Ì								
Unapproved	<u> </u>											<u> </u>
						AU	LT CATE	GORY				
Landi	ng Gear				General ¬₋.		٦		_	1		٦
	Bendir	•		. L	Bend	 	Grain		\vdash	Ovalized		Pressure/Forced
	\vdash	Not Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa		\vdash	Over/Under	—	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	_	-l '	ion Incomplete	\vdash	Part Incorred		Weld
	⊢ ⊣	ed/Crimped		<u> </u>	Burrs	\vdash	┥	tions Incomplete/Unclear	\vdash	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			ļ	Contamination	-	Mainte		—	Part Moved		
	Heat T	reat			Countersink	1	Mislabe	eled	- 1	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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Picklist Print

August-23-12 1:05:18 PM

Work Order ID: 89473

89473

Parent Item: D350-561-045 *D350-561-045*

Parent Item Name: Dual Mirror Accessory Installation, 6 inch Round

Start Date: 23/08/2012

Required Date: 06/09/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP D05.09.15Step 3 pick list revised per D350-561 Rev.

CKJ/JLM

IPP Rev:E

add pick kit DD 10.04.19 verified by:EC

IPP Rev:F 10.09.14 per

IIN revD DD verf:EC

IPP REV:G 12.05.30 PER ECN 12-

596 DD VERF:EC

	OF OUR VENTLE												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			105	Each	1,580.000	**	4			188 .
				Location	1	Loc	<u>Oty</u>	Loc Code					
				ST350			1580				_		
					115371		46		_		_		
					117423		121			· · · ·	_		
					119355		200		7	<u> </u>	_		
					120187		207		2	1	_		
					121185 122416		6 500		_		_		
					122410		500		_		-		
D2011-101		Manufactured	No			105	Each	8.0000		2//	_		
*D2011-10	14 *								**	رآی			
$\mathcal{V}_{6" ext{Mirror}}$.) 1											- R	2
				Location	<u>n</u>	Loc	<u>Qty</u>	Loc Code				9	•
				ST226			8				_		
					79943		8			2	_		
D2012-113		Manufactured	No	•		105	Each	40.0000	2	4.			
プログログログ 19-1 1 Clamp	13*								**	384	W3_	EP	
<u>-</u>				Location	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				ST003			40						
					69758		1		_		_		

84123

39

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Ord	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	•			_		Rework			Skid-tube	Crosstube]	Water Jet	Engineering
Part I	•					Scrap Use-as-is Work Order Update			Machining noforming Large Fab	Small Fab Finishing Composite	4	d. Eng. Coor. re/Packaging Supplier	Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												l	
Equip/Tooling									:				
Operator													
Material													
Setup													
Other			ļ										
Process			l				l						
Supplier			ĺ				l						
Training													
Unapproved													
					•	F.	AUI	T CATE	GORY				
Landi	ing (Gear				General		_	,		_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
:		Cuffs				Contamination		Mainte	enance		Part Moved	_	_
	П	Heat Trea	it			Countersink		Mislabe	eled		Positioned \	Vrong	

Misread

Out of Calibration

Out of Sequence
Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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August-23-12 1:05:18 PM

Work Order ID: 89473

89473

Location

ST059

Parent Item: D350-561-045 *D350-561-045*

Parent Item Name: Dual Mirror Accessory Installation, 6 inch Round

Start Date: 23/08/2012

Required Date: 06/09/2012

Required Qty: 2.00

Start Qty: 2.00

D3635-3

Manufactured

105

68.0000 Each

NAS1149D0363J Purchased

No

85656

68 105 Each

68

Loc Qty

0.0000

Loc Code

NAS1149D0463J Purchased

No

105 Each 29.0000 **

Purchased

No

Location Loc Qty ST351 116289 8 119097 21 105 Each

3,185.000

Loc Code

**



Location	Loc Oty	Loc Code
316	795	
122452	795	
ST300	684	
117885	32	
119017	514	
119075	138	
ST317	1706	
122141	1706	

NCR:	Yes ,	/ No				WORK ORDER NON-O	100	NFORN	ANCE / UPD	ATE	•		e :
									_	***	QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	 No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update	1	Initial	Actio		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						•							
							AUL	T CATE	GORY				
Landi	B C C C	ending entre No racks rushed/0		ntric to (o/s	General Bend BOM/Route Broken/Damaged Burrs		Instructi	on Incomplete ions Incomplete/Ur	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	H	uffs leat Treanspection	Strip in	Tube		Contamination Countersink Cut Too Short		Mainte Mislabe Misread	led		Part Moved Positioned V Power Loss/	_	Other
	R	ipples in	Bend			Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD.



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5. PARTS LIST

Qty -041	Qty -043	-045	Qty -141	Qty -143	Qty -241	Qty -243	Part Number	Description
X	1	1					D350-561-041	SINGLE MIRROR INSTALLATION, RH
	Х						D350-561-043	DUAL MIRROR INSTALLATION, RH
	1	Х		1		1	D350-561-045	MIRROR KIT
		 	Х	1			D350-561-141	SINGLE MIRROR INSTALLATION, RH
		<u> </u>		Х			D350-561-143	DUAL MIRROR INSTALLATION, RH
		-			Х	1	D350-561-241	SINGLE MIRROR INSTALLATION, LH
		 				X	D350-561-243	DUAL MIRROR INSTALLATION, LH
1		/ 1	1		1		D2011-101	Mirror
1		<u> </u>					D2012-101	Arm
1		 					D2012-103	Arm
1		 	1				D2012-105	Arm
			· •		1		D2012-106	Arm
2		 	1		1		D2012-107	Clevis
1							D2012-109	Bracket
1			1		1		D2012-111	Bracket
4		12-					_D2012-113 /	Clamp
1			1		1		D2012-115	Bracket
4		1	2		2		D2022-101	Spacer
4		†		1			D2856-100-325	Abrasion Strip
1*		1*	1*		1*	,	D3014-1	Locknut
			1		1		D3629-1	Bracket
			1		1	-	D3635-1	Gasket
		12					D3635-3 /	Gasket
			1				D3646-1	Arm
					1		D3646-2	Arm
			1				D3646-3	Arm
					1		D3646-4	Arm
			2		2		D4070-041	Clamp
2							AN3-4A	Bolt
2		/ 2	6		6		-AN3-5A	Bolt
1			1		1		AN3-6A	Bolt
2			1		1		AN4-10A	Bolt
3			3		3		AN4-5A	Bolt
14		1-4-	8		8	- 54. TA	AN960JD10 <u></u>	Washer
9		/ 2	8		8		_AN960JD416/	Washer
1*		1*	1*		1*		-AN960JD416L	-Washer
5		2	4		4-		MS21042L3	*Nut (or MS21042-3)
5		y	4		4		MS21042L4	Nut (or MS21042-4)
				1				

*INCLUDED AS PART OF D2011-101 MIRROR